

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001365**Date Inspected:** 31-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	N/A				

**Summary of Items Observed:**

General

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, Scott Croff and Joe Lanz performing fabrication inspection out on the shop floor today.

Mr. Stovall observed welding and other various fabrication operations in bay 2 where the 77, 89 and 114 Meter Mock-Ups were being worked on. Mr. Lanz performed 10% ultrasonic testing of the MU1 Deck Welding Trial between the closed u-ribs partial penetration welds to the decking. Mr. Lanz found two unacceptable indications which ZPMC QC missed. These were on rib U02, weld 2 at Y location 560mm and rib U04, weld 2 at Y location 4600mm. Mr. Croff observed the floor beams in bay 7 being submerged arc welded and several others which were being fitted with stiffeners and tack welded. In bay 4 Mr. Croff observed t-stiffeners being fitted and tack welded. Magnetic Particle testing by ZPMC QC was also observed and while QC accepted the fillet welds, Mr. Croff found issue with the way the welds were wrapped around in to a future splice location.

**Summary of Conversations:**

No conversations held today.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

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**Reviewed By:** Cochran, Jim

QA Reviewer